

Work Order ID 69515

Wednesday, May 11, 2011 2:22:03 PM

Page 1

Item ID: D2151

Accept

Setup Start

Revision ID:

Stop

Item Name: Packer Doubler, Hinge

Start Date: 5/11/2011 Start Qty: 20.00

Required Date: 5/13/2011 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2151

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2151 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

7024.040

B11-5-12

(26)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 11/05/12

conty

(x26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00				26			
Small Fab	Debur								
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00				26	BR	11-5-12	
Hand Finishing									
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00				26x	Ø	m	11/05/12
Powder Coating	START TIME: 3:10 FINISH TIME: 3:40								

M116964

W/O:		WORK ORDER CHANGES					
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Revision ID:

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Start Date: 5/11/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

26x 6 11-05-13

170

Identify as per dwg & Stock Location 6

0.00



Packaging

Memo

0.00

Packaging

11/5/13 260 7

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/16 11

11-05-16 26

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, May 11, 2011 2:22:09 PM

Page 1

Work Order ID: 69515



Parent Item: D2151

Parent Item Name: Packer Doubler, Hinge


Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP ☐ C ☐ 00.10.23 ☐ Re-format (mpp 2101) ☐ EC ☐
 IPP Rev:D 06-04-28 Manufactured on Water Jet JLM
 IPP Rev:E 06-11-24 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			110	sf	48.9000	0.035	0.736842	1.		
													

2024-T3 .040 sheet

Location	Loc Qty	Loc Code
MAT022	48.9	
112291	0.5	
112331	0.7	
113162	47.7	

Bill - 5-12

25

113162

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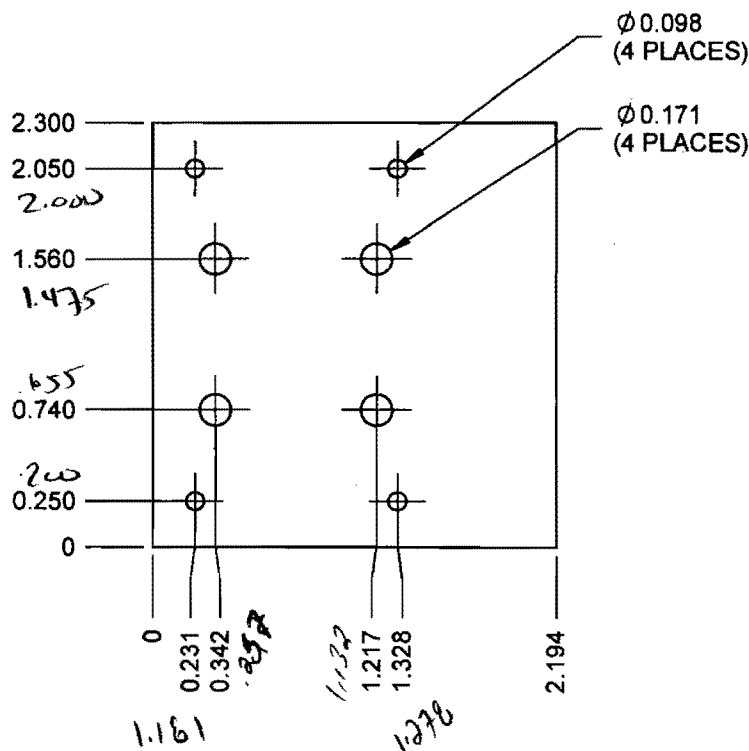
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2151	REV. B SHEET 1 OF 1
DATE 06.10.13	TITLE PACKER SCALE 1:1		
REV	DATE	DESCRIPTION	
A	95.05.01	NEW ISSUE	
B	06.10.13	UPDATE DRAWING	

RELEASED

06.11.20 [Signature]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09515

RM-05-11



D2151 PACKER

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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